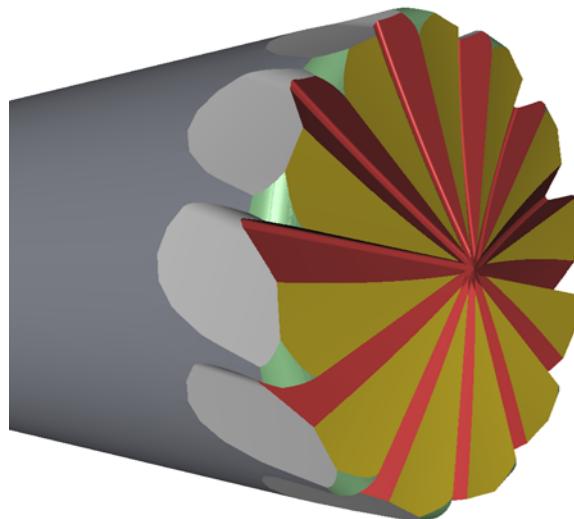


Radius Endmill Ø20 Z12 R2

A01-102



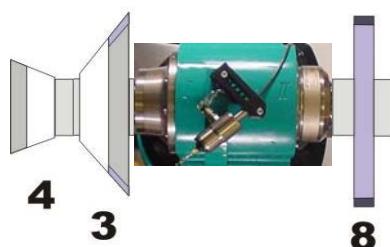
1. Cycletime for Production

Tool specifications				
Diameter 20 mm, Z 12, Length of cutting edge 10 mm, Helix angle 25°				
Material CARBIDE				
Operations				
Feed [mm/Min]	100	120	150	120
Power [kW]	4	2	2	2
Cutting feed [m/s]	18	32	24	24
Used wheels				
Grinding time [s]	145	135	86	54
Total cycle time	7 Min 41			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

8 Ø125 1A1 D64
3 Ø125 12V9 D64
4 Ø75 11V9 D64



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : Sirius HPM
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto

responsible engine KCM

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TECHNOLOGY
FOR TOOLING